

| | | | |
|--|--|---------------------|----------------------|
| DART AEROSPACE LTD | | Work Order: | |
| Description: MID HEIGHT FWD CROSSTUBE | | Part Number: | D135-1027-153 |
| Inspection Dwg: D135-1027-153 Rev: C | | Page 1 of 2 | |

INSPECTION SHEET

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------|--------------------|------------------|--------|--------|----------------------|----------|
| 3.550" TYP | +/-0.005" | | | | | |
| 13.63" TYP | +/-0.030" | | | | | |
| 2.14" REF | +/-0.030" | | | | | |
| 2.75" TYP | +/-0.030" | | | | | |
| Ø.194" THUR 2PL | +0.006" -0.001" | | | | | |
| | | | | | | |
| 17.0" 2PL | +/-0.100" | | | | | |
| Ø.313" THUR 2PL | +0.006" -0.001" | | | | | |
| | | | | | | |
| Ø.472" THUR 4PL | +0.006" -0.001" | | | | | |
| Ø.236" TYP | +0.002" -0.001" | | | | | |

WALL THICKNESS MEASUREMENTS

| LOCATION FROM CL | DWG DIM | R1 | R2 | R3 | R4 | | | | |
|------------------|---------|----|----|----|----|--|--|--|--|
| CL | 0.134" | | | | | | | | |
| 21" | 0.134" | | | | | | | | |
| 21" | 0.134" | | | | | | | | |
| CENTER OF BEND | 0.134" | | | | | | | | |
| CENTER OF BEND | 0.134" | | | | | | | | |

OUTSIDE DIAMETER MEASUREMENTS

| Location | DWG DIM | M1 | M2 | | | | |
|----------------|---------|----|----|--|--|--|--|
| CL | 3.543" | | | | | | |
| CENTER OF BEND | 3.543" | | | | | | |
| CENTER OF BEND | 3.543" | | | | | | |

Crushing

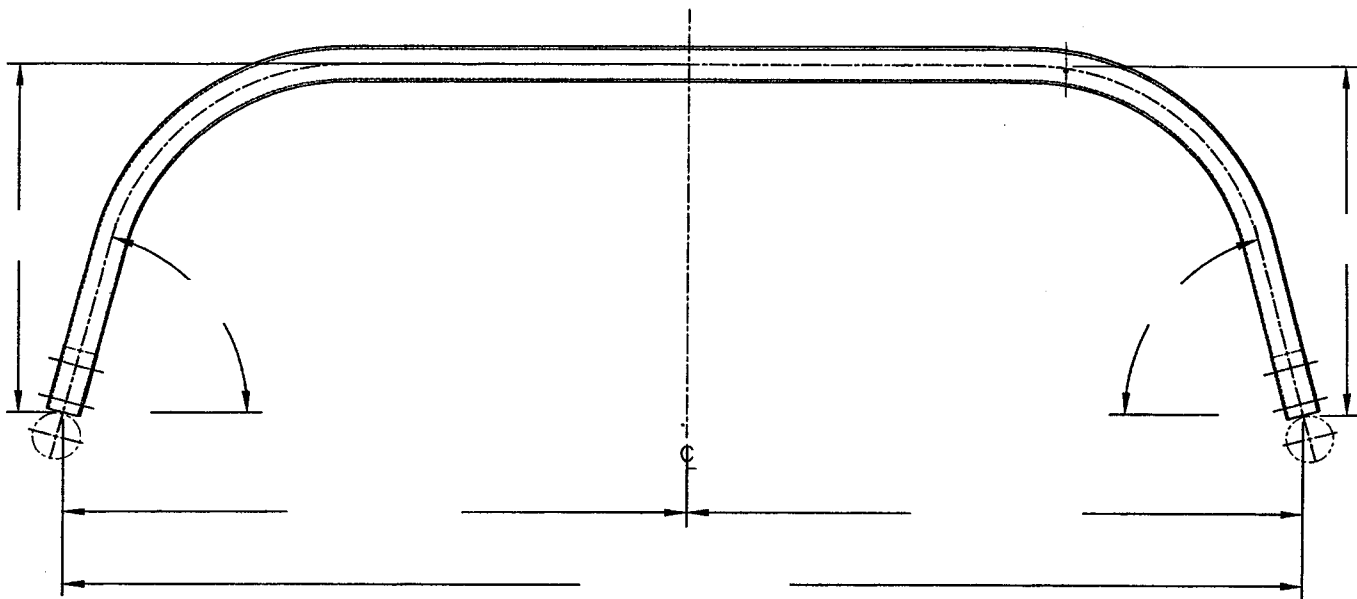
| | | |
|--------|--------|--------|
| | Side A | Side B |
| MAX 2% | | |

TWIST

| | | |
|-----------|--------|--------|
| | SIDE A | SIDE B |
| MAX 0.25" | | |

| | | |
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| Required Dimension | Min | Max |
|--------------------|--------|--------|
| Height | 19.85" | 20.11" |
| 1/2 Span | 40.60" | 40.86" |
| Angle | 70° | 72° |
| Total Span | 81.20" | 81.72" |
| Bending Passes | | |
| Crushing | 0% | 2% |



| | | | | | |
|---------------------|--|--------------------|--|----------------------|--|
| Measured by: | | Checked by: | | QC Inspector: | |
| Date: | | Date: | | Date: | |

| | | | |
|--|--|--------------|--|
| Engineering Approval: (If necessary) | | Date: | |
|--|--|--------------|--|

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|-----------------------|--------------------|
| A | 18/01/16 | New Issue | ED | |
| B | 20.12.18 | Dimensions updated to new drawing Rev. C | MG <i>[Signature]</i> | <i>[Signature]</i> |